



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3301

Job Sheet 206307



Part No: 646.3301

Job Qty: 4 pcs

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/20

Job Tracking No:

Due Date: 3/9/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.3300 REV.A IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.07 AS PER DWG
NC3 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs	3/9/20		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		JAN 31 2020
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S252492



Part: 646.3301

Job No: 206307

Serial No/Batch: S252492

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/31/20

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
					Packaging 1 - 37	
					Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
120	Small Fab - 2 - B4B	4 pcs	3/9/20	0.00 5.56	Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
130	QC 5	4 pcs	3/9/20	0.00 0.00	QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
140	Packaging 3-1 - Stock - B4B	4 pcs	3/9/20	0.00 0.00	QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	

FEB 04 2020

DAS

FEB 27 2020 40 9-89

DAS
84
9-89

CCR 618

				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B		
				150	QC 21 - SA	4 pcs
					QC 21 - SA - 70	21
					QC 21 - SA - 53	3-50 MAR 03 2020

MAR 03 2020

Part Op 110 - Pick Kit

Descriptions: **120** - Small Fab - TWO fastener must be install finger-tight (see note 9) Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7. exp. date: 5/21/07 exp 12/20.

130 - QC5- Inspect part completeness to step on W/O**140** - Identify as per dwg & Stock Location: ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV*****150** - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3310	LH Half - Upper Cutter Assembly	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	3223451
646.3311	RH Half - Upper Cutter Assembly	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	3224197
646.3312	Center Plate	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	3222136
646.3313	Upper Guide	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	3222200
646.3314	Blade	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	3193366
646.3315	Blade	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	3190730
646.3316	Blade	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	3192256
AN3-12A	Bolt	8 Ea (2 ea)	110-Packaging 1 - Pick Kit	3166986
AN3-14A	Bolt	4 Ea (1 ea)	110-Packaging 1 - Pick Kit	3112900
MS21042L08	Nut	72 Ea (18 ea)	110-Packaging 1 - Pick Kit	3950462
MS21042L3	Nut	12 Ea (3 ea)	110-Packaging 1 - Pick Kit	3243985
MS27039-08-19	Screw	72 Ea (18 ea)	110-Packaging 1 - Pick Kit	3250577
NAS1149F0332P	Washer (AN960-10L)	24 Ea (6 ea)	110-Packaging 1 - Pick Kit	32691219
NAS1149FN832P	Washer (AN960-8)	144 Ea (36 ea)	110-Packaging 1 - Pick Kit	348136368-3

10 x 3235228.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.3310	4	16	0
	646.3311	4	16	0
	646.3312	4	17	0
	646.3313	4	31	0
	646.3314	4	35	0
	646.3315	4	37	0
	646.3316	4	38	0
	AN3-12A	8	172	0
	AN3-14A	4	163	0
	MS21042L08	72	2,514	0
	MS21042L3	12	3,303	0
	MS27039-08-19	72	1,153	0
	NAS1149F0332P	24	5,778	0
	NAS1149FN832P	144	6,194	0

Part Specifications

Specifications could not be found.

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube Machining ☐ Large Fab ☐ Cross tube Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering Water Jet ☐ Supplier ☐ Quality		DEPARTMENT/PROCESS		MRB (QSI042)																																																							
Date : _____		Sequence #: _____		QTY Affected : _____																																																									
Description Work Order Deviation		Disposition																																																											
Root Cause		FAULT CATEGORY																																																											
☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Pressure/Forced</td> <td style="width:15%;">Contamination</td> <td style="width:15%;">Power Loss/Surge</td> <td style="width:15%;">Positioned Wrong</td> </tr> <tr> <td>☐</td> <td>☐</td> <td>☐</td> <td>☐</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>☐</td> <td>☐</td> <td>☐</td> <td>☐</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>☐</td> <td>☐</td> <td>☐</td> <td>☐</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>☐</td> <td>☐</td> <td>☐</td> <td>☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>☐</td> <td>☐</td> <td>☐</td> <td>☐</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>☐</td> <td>☐</td> <td>☐</td> <td>☐</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> <tr> <td>☐</td> <td>☐</td> <td>☐</td> <td></td> </tr> </table>				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	☐	☐	☐	☐	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	☐	☐	☐	☐	Crushing	BOM/Route	Grain Direction	Drawing	☐	☐	☐	☐	Cracks	Broken/Damage/Defect	Weld	Finish	☐	☐	☐	☐	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	☐	☐	☐	☐	Marks/Chatter	Drill Holes	Out of Sequence	Misread	☐	☐	☐	☐	Mislabeled	Fit/Function	Off-set/Set-up		☐	☐	☐	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																																																										
☐	☐	☐	☐																																																										
Bending	Misaligned/off center	Folio/Program	Outside Tolerance																																																										
☐	☐	☐	☐																																																										
Crushing	BOM/Route	Grain Direction	Drawing																																																										
☐	☐	☐	☐																																																										
Cracks	Broken/Damage/Defect	Weld	Finish																																																										
☐	☐	☐	☐																																																										
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing																																																										
☐	☐	☐	☐																																																										
Marks/Chatter	Drill Holes	Out of Sequence	Misread																																																										
☐	☐	☐	☐																																																										
Mislabeled	Fit/Function	Off-set/Set-up																																																											
☐	☐	☐																																																											
Other/Details:		Completed By																																																											
Lead hand / Supervisor		QC / QA Coordinator																																																											